

Date: Monday, 12/01/2009 2:37:42 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : AFT BASE
<b>Job Number</b> : 44677	
<b>Estimate Number</b> : 13033	
<b>P.O. Number</b> :	<b>Part Number</b> : D36519
<b>This Issue</b> : 12/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3651 REV.B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 42118	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 06/02/2009 <b>Qty:</b> 4 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.01.13</u>	
<b>Comment</b> : Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD Est Rev:C ecn1162 08-04-02 DD verified by: EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S26GA	304/316 0.018 SHEET
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**Comment:** Qty.: 0.4526 sf(s)/Unit Total : 1.8102 sf(s)  
 304/316-SS sheet 26 ga (0.018" thick)  
 Batch: 108398 B 9-5-25

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3651  
 Dwg Rev: B B 9-5-25  
 Prog Rev: B

(S)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

80965/25 (B)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1  
 Identify and stock  
 Location: ST168

880965/25 (B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 2:37:42 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BASE

Job Number: 44677

Part Number: D36519

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/06 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF*  
09-05-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <u>LH077</u>
<b>Description:</b> Inside Doubler		<b>Part Number:</b> D3651-9
<b>Inspection Dwg:</b> D3651	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.25	+0.004/-0.001	0.253	X			
0.250	+/-0.010	0.250	X			
0.500	+/-0.010	0.505	X			
6.33	+/-0.030	6.338	X			
9.81	+/-0.030	9.867	X			
2.818	+/-0.010	2.819	X			
2.100	+/-0.010	2.099	X			
2.100	+/-0.010	2.099	X			
2.575	+/-0.010	2.574	X			
2.000	+/-0.010	1.998	X			
5.514	+/-0.010	5.514	X			
2.750	+/-0.010	2.750	X			
2.200	+/-0.010	2.198	X			
2.371	+/-0.010	2.372	X			
1.325	+/-0.010	1.324	X			
3.112	+/-0.010	3.111	X			
1.400	+/-0.010	1.401	X			
5.514	+/-0.010	5.514	X			

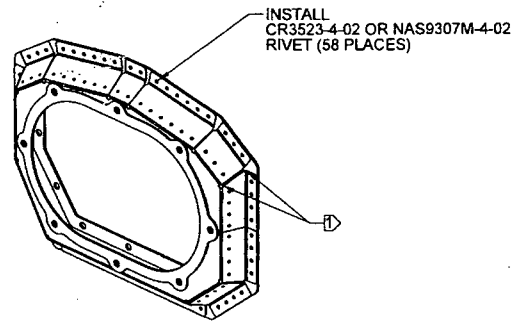
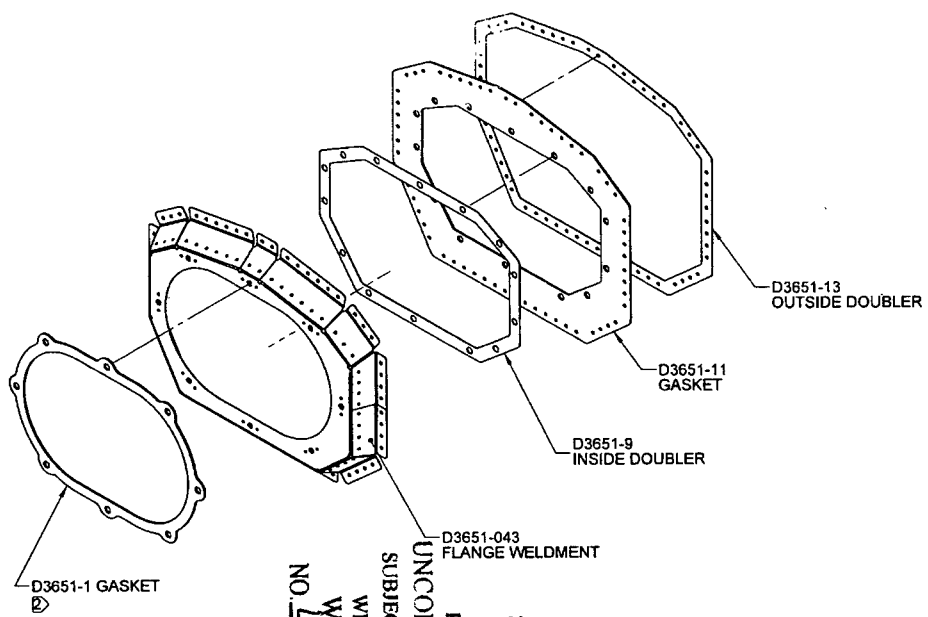
<b>Measured by:</b> <u>RB</u>
<b>Date:</b> <u>9-5-25</u>

<b>Audited by:</b> <u>S</u>
<b>Date:</b> <u>09/05/25</u>

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.17	New Issue	KJ/DD	<u>[Signature]</u>

8 7 6 5 4 3 2 1



PART LIST

QTY	PART NUMBER	DESCRIPTION
X	D3651-041	AFT BASE ASSEMBLY
1	D3651-043	FLANGE WELDMENT
1	D3651-1	GASKET
1	D3651-9	INSIDE DOUBLER
1	D3651-11	GASKET
1	D3651-13	OUTSIDE DOUBLER
58	CR3523-4-02 or NAS9307M-4-02	RIVET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
NO. 27677

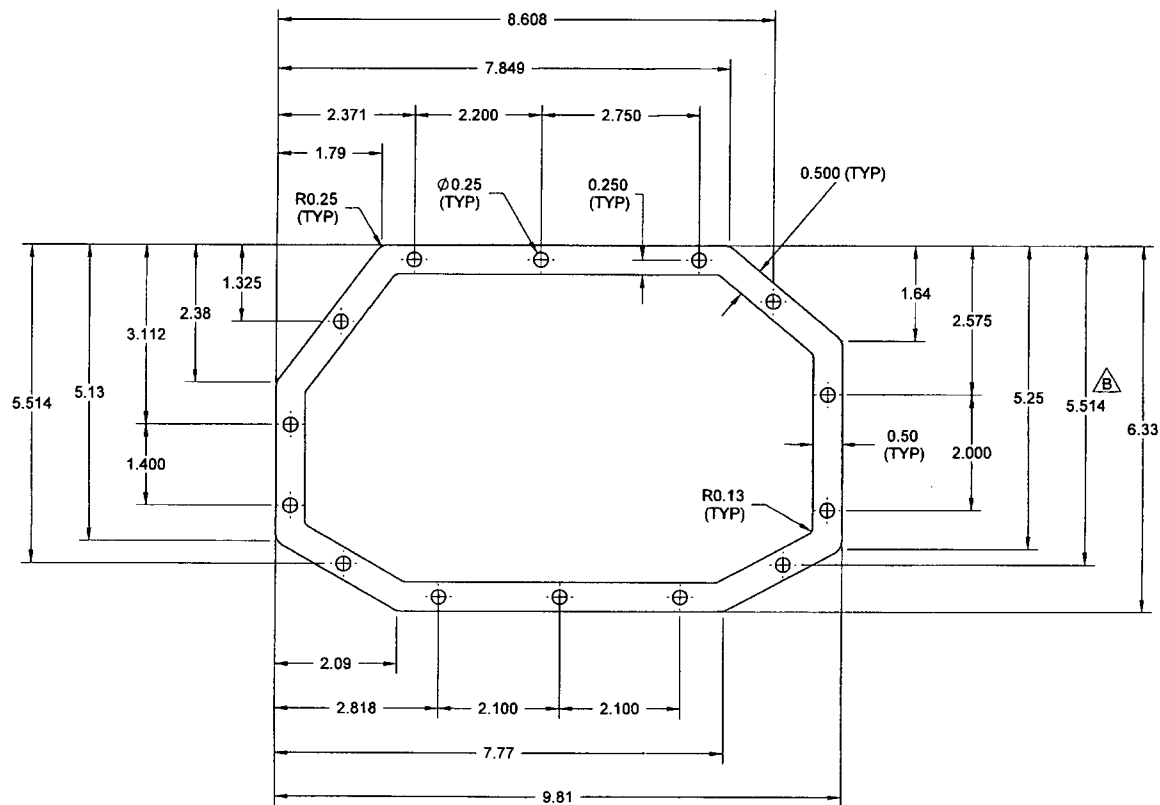
D3651-041 AFT BASE ASSEMBLY

- D3651-041 NOTES:
- 1) SEAL ALL MATING SURFACES AND GAPS USING PROSEAL 700 FIRE WALL SEALANT
  - 2) INSTALL D3651-1 USING 3M HIGH PERFORMANCE CONTACT ADHESIVE 1357
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 1.6 lbs

RELEASED  
08.03.27

B	SHEET 1: GENERAL UPDATE SHEET 2: 8.74 WAS 8.50; 0.88 WAS 0.96, REMOVED ANGLE SHEETS 4, 5, 6, 8 & 9: GENERAL DIMENSIONAL UPDATE SHEET 7: 5.514 WAS 5.504	RF	08.01.07
A	NEW ISSUE	RF	07.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. B
CHECKED	RF	D3651	SHEET 1 OF 9
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	AFT BASE ASSEMBLY	1:4
DE APPR.	RF	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.01.07		

8 7 6 5 4 3 2 1



**D3651-9 INSIDE DOUBLER**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 0.018 (26 GAUGE) SHEET, PER MIL-S-5019 (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.07 lbs.

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	ME	DRAWING NO.	REV. B
MFG. APPR.	ME	D3651	SHEET 7 OF 9
APPROVED	ME	TITLE	SCALE
DE APPR.	ME	AFT BASE ASSEMBLY	1:2
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